

Work Order ID 65207

January 10, 2011 7:40:42 AM



Page 1

Item ID: D3654-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 1/10/11 Start Qty: 4.00



Cust Item ID:

Required Date: 1/21/11 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 1/10/11 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3654	Rev B

Pro →

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3654 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

304 .063

B11-1-11

(4)

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-1-11

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sublot
to Rev B Dwg

(4)

W/O: 65207		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/01/14	#100	update Rev on PAZ sheet on w/o 65207	JA	11.01.13			S 11/01/14	

Part No: D3654-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65207

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Item ID: D3654-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 1/10/11

Start Qty: 4.00



Cust Item ID:

Required Date: 1/21/11

Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location 188

0.00



Packaging

Memo

0.00

Packaging

release 7x

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/12 MF11-01-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 10, 2011 7:40:42 AM

Page 1

Work Order ID: 65207



Parent Item: D3654-1



Parent Item Name: Doubler

Start Date: 1/10/11

Required Date: 1/21/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-10-29 DD verified by: EC
IPP Rev:B ecn1162 08-04-02 DD verified by:ec
IPP Rev:C 08-09-17 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

34.8100

0.35

1.473684



B11-11

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT

34.81

111323

0

115953

34.81

115953

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	65207
Description: Doubler		Part Number:	D3654-1
Inspection Dwg: D3654	Rev: A B	Page 1 of 1	

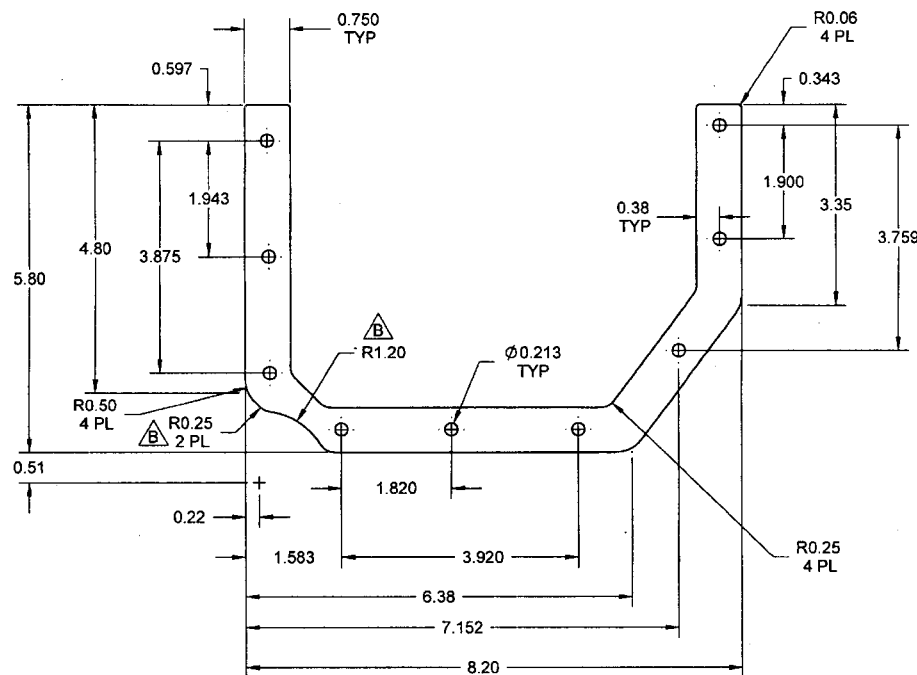
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.213	+0.005/-0.001	.215	*		V HB02	
0.750	+/-0.010	.752	*		V	
0.597	+/-0.010	.594	*		V	
1.943	+/-0.010	1.943	*		V	
3.875	+/-0.010	3.877	*		V	
4.80	+/-0.030	4.790	*		V	
5.80	+/-0.030	5.780	*		V	
1.583	+/-0.010	1.583	*		V	
1.820	+/-0.010	1.822	*		V	
3.920	+/-0.010	3.922	*		V	
6.38	+/-0.030	6.38	*		V	
7.152	+/-0.010	7.154	*		V	
8.20	+/-0.030	8.214	*		V PRO HB02	
0.343	+/-0.010	.345	*		V	
1.900	+/-0.010	1.899	*		V	
3.35	+/-0.030	3.35	*		V	
3.759	+/-0.010	3.759	*		V	
0.38	+/-0.030	.382	*		V	
0.063	+/-0.010	.057	*		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-1-11	Date: 11/21/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	
B	09.12.17	Dimensions updated per Dwg Rev B	KJ	



D3654-1 DOUBLER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65207
C2110110

RELEASED
08-09-16

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.063 (16 GAUGE) SHEET PER AMS 5513/5524 (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3654-1 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

B	ADD R1.20 & R0.25 (ZN C6); MATERIAL NOTE AMS 5513/5524 WAS MIL-S-5019 (ZN A6); REFORMATTED DRAWING TO CURRENT STANDARD	RF	08.09.11
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3654	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	08.09.11	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	